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RBE105-14181W4
Job Sheet 203714



Part No: RBE105-14181W4

Job Qty: 1 pcs

Part Name: Needle Bearings Extractor



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/26/19

Job Tracking No:

Due Date: 1/24/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBE105-14181W4 Rev.C IPP Rev. A 18.12.10 New issue DP Verify DD/IPP Rev. B 19.09.09 drawing
revision DP Verify DD

Ship Via:

Bill of Materials

Job Routing									
Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	1 pcs	1/24/20	0.00	0.25	Small Fab - 1		GP 19-12-09.	
						Small Fab - 2			
						Small Fab - 3			
						Small Fab - 4			
						Small Fab - 5			
						Small Fab - 6			
						Small Fab - 7			
						Small Fab - 8			
						Small Fab - 9			
110	QC 5	1 pcs	1/24/20	0.00	0.00	QC 5 - 10		DAS DEC 11 2019 40 9-89	
						QC 5 - 12			
						QC 5 - 17			
						QC 5 - 18			
						QC 5 - 19			
						QC 5 - 22			
						QC 5 - 24			
						QC 5 - 3			
						QC 5 - 43			
						QC 5 - 49			
						QC 5 - 51			
						QC 5 - 58			
						QC 5 - 68			
						QC 5 - 9			
						QC 5 - 50			
						QC 5 - 30			
						QC 5 - 40			
						QC 5 - 61			
						QC 5 - 81			
						120	Packaging 3-1 - Stock - B4B		1 pcs
Packaging 3 - 2 - B4B									
Packaging 3 - 3 - B4B ✓									
Packaging 3 - 4 - B4B									
Packaging 3 - 5 - B4B									
Packaging 3 - 6 - B4B									
Packaging 3 - 7 - B4B									
Packaging 3 - 8 - B4B									
Packaging 3 - 9 - B4B									
Packaging 3 - 10 - B4B ✓									
130	QC 21 - FG	1 pcs	1/24/20	0.00	0.00	QC 21 - FG - 21 ✓		FA180 DAS 21 9-89 DEC 12 2019	
						QC 21 - FG - 70			
						QC 21 - SA - 53			

Part Op 100 - Assemble as per drawing see note 8 and 9.
 Descriptions: 110 - QC5- Inspect part completeness to step on W/O
 120 - Identify as per dwg & Stock Location: _____ The tool must be packaged with a desiccant bag into a tight fitting sealed plastic bag as per DWG.
 130 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
91290A230	Black Oxide Steel Socket Head Screw, M5 X 0.8 mm X 14 mm	22 Ea (22 ea)	100-Small Fab - 1	013356
RBE105-14181W4-1	Long Shell 144	2 pcs (2 ea)	100-Small Fab - 1	216720
RBE105-14181W4-11	Puller 137	1 pcs (1 ea)	100-Small Fab - 1	228820
RBE105-14181W4-13	Screw 141C	1 pcs (1 ea)	100-Small Fab - 1	232741
RBE105-14181W4-15	Base 141C	2 pcs (2 ea)	100-Small Fab - 1	225794
RBE105-14181W4-17	Clamping Ring 137A	1 pcs (1 ea)	100-Small Fab - 1	217748
				226413

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	91290A230	22	100	0
	RBE105-14181W4-1	2	10	0
	RBE105-14181W4-11	1	5	0
	RBE105-14181W4-13	1	5	0
	RBE105-14181W4-15	2	6	0
	RBE105-14181W4-17	1	8	0

Part Specifications

Specifications could not be found.

DART
AEROSPACE

Container No: S238579



Part: RBE105-14181W4

Job No: 203714

Serial No/Batch: S238579

Revision: B

Inspector:

Exp Date:

Instructions:

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www.dartaerospace.com

Plex 11/26/19 10:57 AM Dart.lajeunesse.marie

Date: 12/09/19

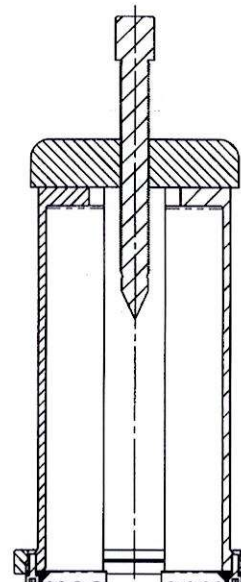
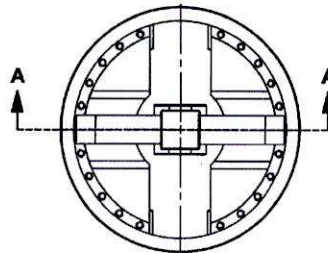
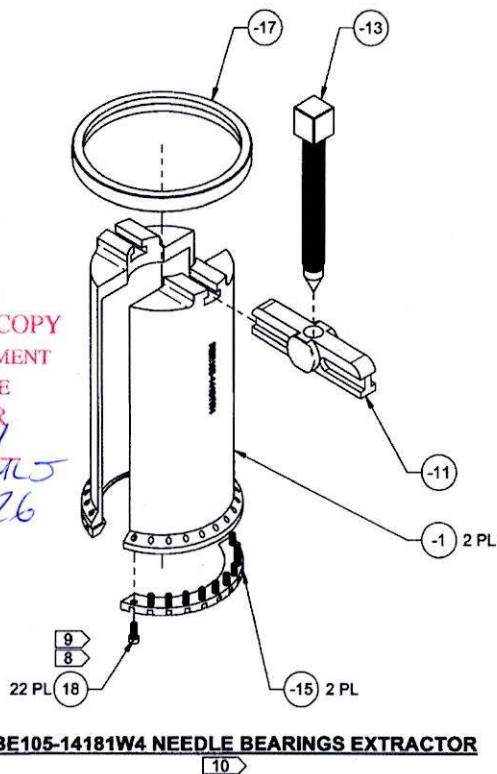
ITEM #	QTY	PART #	PART TITLE
-1	2	RBE105-14181W4-1	SHELL
-11	1	RBE105-14181W4-11	PULLER
-13	1	RBE105-14181W4-13	SCREW
-15	2	RBE105-14181W4-15	BASE
-17	1	RBE105-14181W4-17	CLAMPING RING
18	22	McMaster#91290A230 OR EQUIV	BLACK OXIDE STEEL SOCKET HEAD SCREW M5 X 0.8mm X 14mm LG.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 203714
MLJ
19-11-26

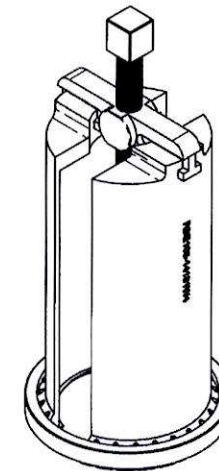
RBE105-14181W4 NEEDLE BEARINGS EXTRACTOR

NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = $\pm 0.1"$ / $\pm 1"$
X.XX = $\pm 0.01"$ / $\pm 0.5"$
X.XXX = $\pm 0.005"$ / $\pm 0.1"$
X.XXXX = $\pm 0.0005"$ / $\pm 0.05"$
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $\pm 0.005"$
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFICATION: N/A
- 7) ASSEMBLE AS SHOWN
- 8) APPLY RED THREADLOCKER LOCTITE 263/262 ON THREADS OF ITEM 18 THEN ASSEMBLE WITH ITEM -1, AND REMOVE EXCESS
- 9) INSTALL ITEM 18 HAND TIGHT
- 10) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG



SECTION A-A



FOR OLDER REV'S SEE PREVIOUS PDF'S
TEMPLATE UPDATED PER DART HBY STANDARDS
ITEM -1 WAS 3 PARTS ASSY IS ITEM -1 SINGLE PART
ITEM -3, -5 & -7 DELETED
ITEM -19 McMaster#93070A125 QTY 18 CHANGED FOR ITEM 18
McMaster#91290A230 QTY 22
ITEM -9 ASSY DELETED
ITEM -1 COMPLETE RE-DESIGN, FINISH CLEAR ANODIZE CHANGED FOR RED ANODIZE
ITEM -11 DIMENSION 2X .725 ± 0.005 CHANGED FOR 0.725, DIMENSION 4X 2.00 CHANGED FOR 2.000 TYP, DIMENSION 4X .50 CHANGED FOR 0.500 TYP, DIMENSION 2X $\phi 1.34$ CHANGED FOR $\phi 1.340$ TYP, DIMENSION .285 ± 0.005 CHANGED FOR 0.285 TYP, DIMENSION 2.885 REMOVED, DIMENSION 2 X .275 REMOVED, DIMENSION 1.275 CHANGED FOR 1.28, MATERIAL 4140/4142 Q&T ZINC PLATE CHANGED FOR 4140 (28-32 RC) BLACK OXIDE, DIMENSION 0.608 ADDED
ITEM -13 DIMENSION 1.0 CHANGED FOR 1.00, DIMENSION .325 CHANGED FOR .33, DIMENSION 5.25 AND 5.50 REMOVED, DIMENSION 6.55 ADDED, DIMENSION 1.1 REMOVED, MIN THREAD RELIEF ADDED, CENTER DRILL ADDED, MATERIAL 4140/4142 Q&T ZINC PLATE CHANGED FOR 4140 (28-32 RC) BLACK OXIDE
ITEM -15 HEAT TREAT RC 45-50 CHANGED FOR 48-52 Rc, FINISH ZINC PLATE CHANGED FOR ZINC PLATE YELLOW, DIMENSION .32 CHANGED FOR 0.315, DIMENSION $\phi 5.100$ B.C CHANGED FOR $\phi 5.236$ B.C, DIMENSION 2.081 CHANGED FOR 2.087 ± 0.001 , DIMENSION R2.145 REMOVED, DIMENSION R2.439 CHANGED FOR $\phi 4.902 \pm 0.001$, DIMENSION 8X 15" REMOVED, DIMENSION .581 REMOVED, DIMENSION 9X $\phi 0.217$ THRU ALL $\phi 0.39 \pm 0.20$ 9 PL EQ.SP., CHANGED FOR $\phi 0.217$ THRU $\phi 0.394 \pm 0.20$ 9 PL EQ.SP., DIMENSION .650 REMOVED, DIMENSION $\phi 5.580$ CHANGED FOR $\phi 5.5915.590$
ITEM -17 MATERIAL 4140/4142 Q&T ZINC PLATE CHANGED FOR 4140 (28-32 RC) ZINC PLATE YELLOW, DIMENSION .30 CHANGED FOR 0.31, DIMENSION $\phi 5.595$ CHANGED FOR $\phi 5.598/5.595$, DIMENSION .60 CHANGED FOR 0.61, DIMENSION $\phi 5.510$ CHANGED FOR $\phi 5.492$

REV.	DESCRIPTION	ECN #	BY
DESIGN	VM		
DRAWN	VM		
CHECKED	KPT		
MFG. APPR.	JFO		
APPROVED			
DATE	2019-11-14		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. C SHEET 1 OF 6
TOOL PART # RBE105-14181W4	TITLE NEEDLE BEARINGS EXTRACTOR	SCALE NTS
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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details: _____					